

Date: Tuesday, 12/20/2005 2:50:22 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 25295
 Estimate Number : 10481
 P.O. Number : N/A
 This Issue : 12/20/2005 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : N/A

Drawing Name : STIFFENER
 Part Number : D2353
 Drawing Number : D2353 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 1/20/2006

Stack of 10

Qty: 10 Um: Each

Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE USER
 Comment : Est Rev: A Removed from 9 Digit 05-11-10 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.1536 sf(s)/Unit Total : 0.9217 sf(s)
 Material: 2024-T3 .050 sheet
 Aluminum (QQ-A-250/5)
 Batch: M 15053

En 06/02/06

2.0 SHEAR SHEAR



Comment: SHEAR
 Cut blanks: 1.382" x 15.25"

En 06/02/06 x 10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2353 7 dwg D2353

J.L 06-02-06 10

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06-02-06 10

5.0 QC8 SECOND CHECK




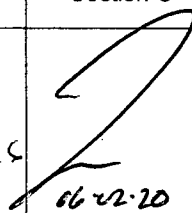

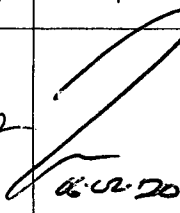
Comment: SECOND CHECK

En 06/02/06 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/02/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/16	6	1 piece was bent out of tolerance band wasn't square. Small at one end, large at the other.		Scrap + destroy	SB 06/02/16	 06-02-20	 06-02-20	 06-02-20

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: STIFFENER

Job Number: 25295

Part Number: D2353

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2353

JB 06/02/16

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FB 06.02.21

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL 06 02 21

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 02 22

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5171

04/2/22 (9)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/23

Job Completion



06.02.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25295
Description: Stiffener		Part Number:	D2353
Inspection Dwg: D2353 Rev: B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

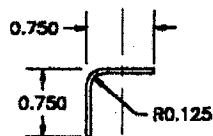
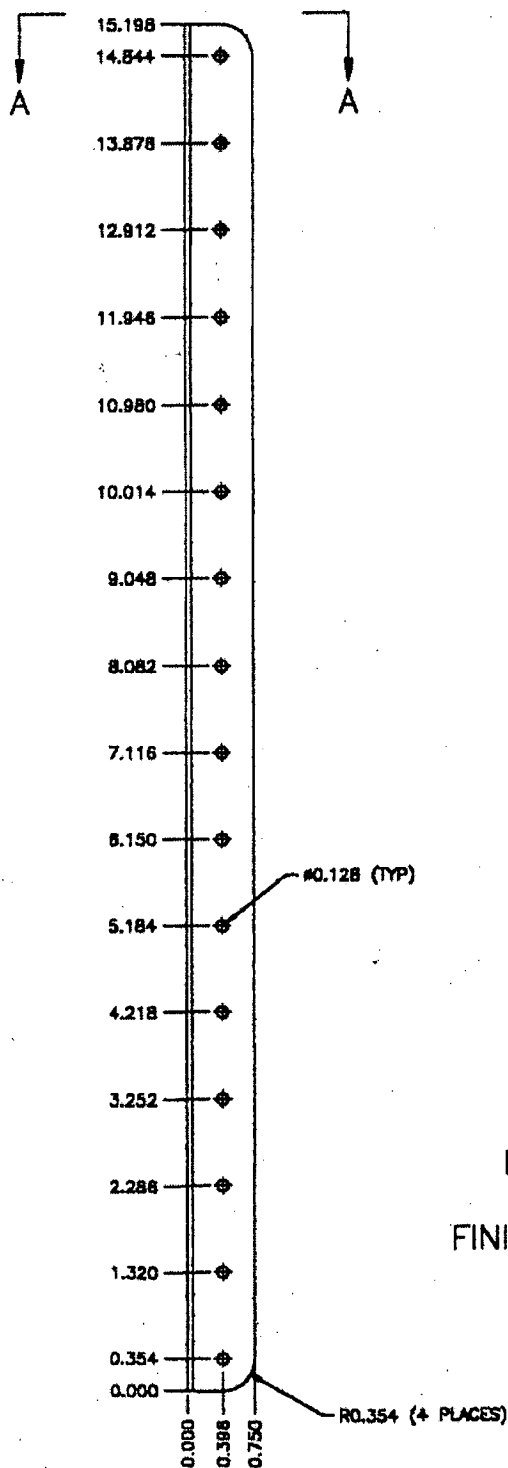
[illegible]

Measured by:	J.L	Audited by:	E	Prototype Approval:	N/A
Date:	06.02.06	Date:	06/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO. D2353	REV. B SHEET 1 OF 1
CHECKED BW	APPROVED QA	TITLE STIFFENER	SCALE 1:2
DATE 95:02:10			
B	95:02:23	ADD TEXT	



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
T

25295

MATERIAL 2024-T3 0.050 THICK
QQ-A-250/5
FINISH: POWDER COAT CRINKLE BLACK